ASAP

Work Order ID 109862

D3243-041 *109862*

B109862

December-03-13 2:57:02 PM

Item ID: D3243-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket

Start Date: 12/03/13 **Start Qty:** ~~5.00~~ 10 *5* *12*

Required Date: 12/06/13 **Req'd Qty:** ~~5.00~~ *5*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3243	Rev A								
110	HAAS CNC VERTICAL MACHINING #1	0.00				12	0		Ac 13.12.06
110	**Memo**	0.00							
Waterjet	1-Cut as per Dwg								
FLOW CNC Waterjet	Dwg Rev: A								
6061-063	Prog Rev: A								
	2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				12	0		Ac 13.12.06
120	**Memo**	0.00							
QC									
Quality Control									

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Item ID: D3243-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket

Start Date: 12/03/13 **Start Qty:** 5.00 *5*

Required Date: 12/06/13 **Req'd Qty:** 5.00 *5*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00 JAB				12			
130									
QC	**Memo**	0.00 12/12/09							
Quality Control									
150		0.00							12/12/09
150	NC BRAKE			DAS 30 9-89		12			
Brake NC	**Memo**	0.00							
Brake NC	Form as per Dwg D3243								
160	QC5- Inspect part completeness to step on W/O	0.00 DAS 27 9-89				12			
160									
QC	**Memo**	0.00 12/12/09							
Quality Control									

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Item ID: D3243-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket

Start Date: 12/03/13 **Start Qty:** 5.00 *5*

Required Date: 12/06/13 **Req'd Qty:** 5.00 *5*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Chemical Conversion Coat per QSI005 4.1	0.00				12	76	13	12-12-10
170									
HandFinish	**Memo**	0.00							
Hand Finishing									
180		0.00							DAS 36 9-89
180	Small Fab					12x			14/01/16
Small Fab	**Memo**	0.00							
Small Fab	Install Inserts as per Dwg D3343								
190	QC5- Inspect part completeness to step on W/O	0.00				12			DAS 27 9-89
190									
QC	**Memo**	0.00							14/1/16
Quality Control									

Item ID: D3243-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Bracket
Start Date: 12/03/13 **Start Qty:** 5.00 *5* **Cust Item ID:**
Required Date: 12/06/13 **Req'd Qty:** 5.00 *5* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M126898	0.00				12	0	H-1-16	DAS 34
200 Powdercoat	**Memo**	0.00							
Powder Coating	*****Mask Holes****** START TIME: 1:25 OVEN TEMPERATURE: 380° FINISH TIME: 1:55								
210	QC3- Inspect Part Finish	0.00				12			
210 QC	**Memo**	0.00							
Quality Control	DAS 27 9-89 14/1/16								
220	Identify as per dwg & Stock Location: ST228	0.00				12x		14-01-17	DAS 28 9-89
220 Packaging	**Memo**	0.00							
Packaging									

Work Order ID 109862

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December-03-13 2:57:02 PM

Item ID: D3243-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Bracket **Stop** *NS2*

Start Date: 12/03/13 **Start Qty:** 5.00 *5*

Required Date: 12/06/13 **Req'd Qty:** 5.00 *5*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	**Memo**	0.00							
Quality Control									

14-01-17

14-01-17

Picklist Print

December-03-13 2:57:01 PM

Work Order ID: 109862
Parent Item: D3243-041
Parent Item Name: Bracket
Start Date: 12/03/13 **Required Date:** 12/06/13
Start Qty: 5.00 **Required Qty:** 5.00

Comments: IPP Rev:A New Issue 05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-032-EF Inserts		Purchased	No			180	Each	50.0000	4	~~20~~ 40	13/12/10		DAS 36 9-89
				Location		**Loc Qty**		**Loc Code**					
				ST283		50							
				117168		5							
				117226		45				45			
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			110	sf	775.9565	0.5499	~~3~~ 6	Ae 13.12.06		
				Location		**Loc Qty**		**Loc Code**					
				MAT021		775.9565							
					123135	120.2625							
					124003	72.113							
					M124446	94							
					M126075	89.242							
					M127006	151.99							
					M127420	248.349				~~127420~~			

M127922 3x

~~M124445~~ → 6.48

DART AEROSPACE LTD	Work Order:	109862
Description: Bracket	Part Number:	D3243-1
Inspection Dwg: D3243 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.920	+/-0.010	11.920	-		T	JKM-06
11.420	+/-0.010	11.420	-		T	
Ø0.201	+0.005/-0.000	.204	-		V	JKM-05
Ø0.290	+0.005/-0.000	.290	-		V	
1.375	+/-0.005	1.375	-		V	
5.273	+/-0.010	5.273	-		T	
0.500	+/-0.010	.500	-		V	
0.500	+/-0.010	.500	-		V	
0.750	+/-0.010	.750	-		V	
R0.50	+/-0.030	.50	-		RG	
5.360	+/-0.010	5.360	-		T	
5.810	+/-0.010	5.810	-		T	
6.560	+/-0.010	6.560	-		T	
R0.250	+/-0.030	.250	-		RG	

Measured by:	AC
Date:	13.12.06

Audited by:	SKP
Date:	13/12/06

Prototype Approval:	N/A
Date:	N/A

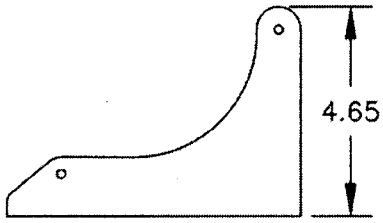
Rev	Date	Change	Revised by	Approved
A	04.02.18	New Issue (P/O D044-715-011)	KJ/JLM	
B	04.04.19	Removed dimensions from FAI	KJ/RF	

DART

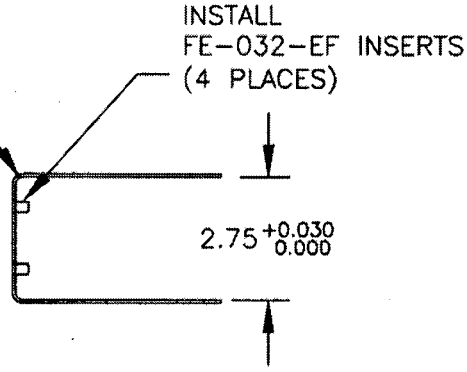
COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2

A	04.01.09	NEW ISSUE







D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

RELEASED
04.02.03

W/O 104862

D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)

1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC M6061T6S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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